

Date: Monday, 2/27/2006 4:17:43 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL ARM
Job Number	: 25965		
Estimate Number	: 10868		
P.O. Number	: <i>NIA</i>	Part Number	: D32061
This Issue	: 2/27/2006 S.O. No. : <i>NIA</i>	Drawing Number	: D3206 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i> Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: <i>NIA</i>	Material	: <i>NIA</i>
Written By	: <i>See Comment Below</i>	Due Date	: 3/20/2006
Checked & Approved By	: <i>KJ 06.02.28</i>	Qty:	2 Um: Each
Comment	: Est. A 04.04.15 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *00000685*
 Email or Ship DXF file to vendor
 Laser Cut D3206-1 as per Dwg.D3206
 Material release note is required

AP
06/03/10

2.0	D32061F	Pedal Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pedal Arm

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

06/04/18 *2*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.04.24

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

AD *06.05.02* *02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:17:43 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ARM

Job Number: 25965

Part Number: D32061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DC 06/05/03 (2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 6/5/3 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P 6/5/3 (2)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/05/04 (2)

Job Completion



W 06.05.04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

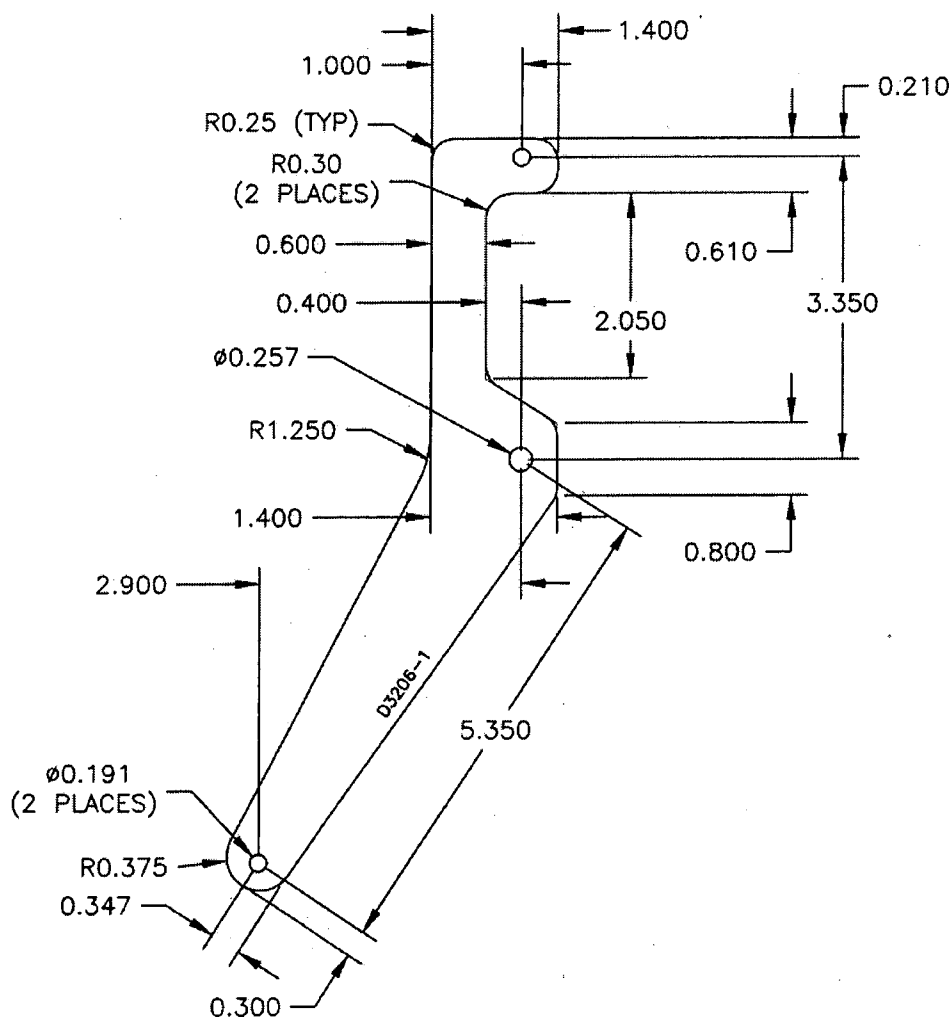
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3206	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE PEDAL ARM	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNERS 0.005 TO 0.010
- 2) MATERIAL: AISI 4130N SHEET, 11 GAUGE (M4130N-S125)
- 3) FINISH POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 018
- 4) ENGRAVE DART P/N AS SHOWN
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25965

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CERTIFICATE OF TEST

RECEIVED CERTIFICATION
 Industrial Laser Cutting
 13006 Main Street
 Oroville, CA 95964
 (530) 838-4444

Now, this report is a statement of the
 results of the examination of the
 material and is not a statement of
 conformity with the requirements of the
 specification.

PO 952
 PO 685

CUSTOMER ORDER NUMBER

10810

CUSTOMER PART NUMBER

SOLD TO: DEMEL AIRCRAFT CORP
 101 3440 AIRPORT ROAD
 PENTICTON BC V2A 8X1

SHIP TO

DEMEL AIRCRAFT
 C/O BETHELM STEEL CORP
 13006 MAIN STREET
 OROVILLE, CA 95964

Supplier for UAT

Description: 4130 HS DESCALED AO PLATE AMS 6345
 3/16" X 74" X 74" RECTANGLE REMNANT Line Total: 116 LB
 HEAT: C0007 ITEM: 508730

Specifications:

MIL S 18729 COND N C*
 *AMD 1

AMS 6345 95
 AMS 2301 H

UNS G41300

CHEMICAL ANALYSIS

C	MN	P	S	CU	SI	NI	CR
0.31	0.52	0.008	0.003	0.15	0.25	0.09	0.91
MO	V	AL	CB				
0.19	0.049	0.022	0.001				

RCPT: R983907

MILL: BETHLEHEM STEEL CORP

COUNTRY OF ORIGIN: USA

MECHANICAL PROPERTIES

DESCRIPTION	YLD STR	ULT TEN	%ELONG	%RED	HARDNESS
	PSI	PSI	IN 02 IN	IN AREA	
	94500.0	120900.0	19.0		

DEVELOPED HARDNESS 042 RC

BEND: Y

GRAIN SIZE: 7 - 8

The above data were transcribed from the manufacturer's Certificate of Test after verification for completeness and specification requirements of the information on the certificate. All test results remain the subject of examination.

We hereby certify that the material covered by this report will meet the applicable requirements described herein, including any specification forming a part of the description.

The willful reporting of false, fictitious, or fraudulent statements in connection with test results may be punishable as perjury under federal statutes.

Material did not come in contact with mercury while in our possession.

MELINDA ENDRESE

Melinda Endrese

CERTIFICATE OF TEST

CUSTOMER ORDER NUMBER

10038

CUSTOMER PART NUMBER

SOLD TO: DEMEL AIRCRAFT CORP
101 3440 AIRPORT ROAD
PENTICTON BC V2A 8X1

SHIP TO:

DEMEL AIRCRAFT
C/O BETTA'S SERVICES
1306 MAIN STREET
OROVILLE WA 98844

Description: 4130 CR AQ OILED SHEET COND N
125" X 36" X 144"
HEAT: 2122580

AMS 6340
Line Total: 183.6 LB

ITEM: 508694

MATERIAL IS FREE FROM MERCURY CONTAMINATION

DECARB: OK

AMS NO: 2301

SEVERITY: 0.01

FREQUENCY: 0.02

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Material did not come in contact with mercury while in our possession.

MELINDA ENDRES

